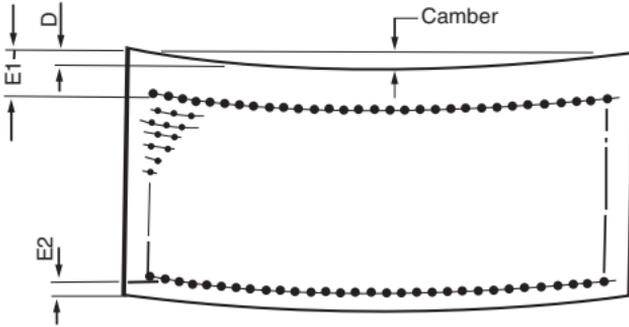


CAMBER

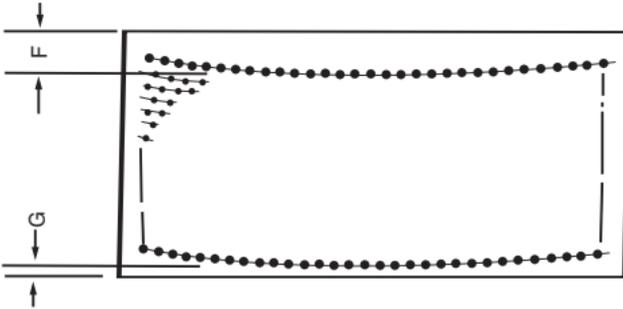
Camber is the greatest deviation of a side edge from a straight line. The measurement is taken over the entire length of the concave side with a straight line.

On perforated sheets with different side margins ($e_2 > e_1$) it is possible to produce a camber effect. This effect is the deflection (d) between one of the longitudinal edges and a straight line supported by the ends of the sheet.

The magnitude of the deflection (d) depends on the length, width, thickness, open area, type of material and relation of e_2 to e_1 .



If sheets are cut after perforation, the camber refers only to the perforated pattern. (See sketch below F & G.)



Designers are requested to avoid different margins whenever possible.

Max. Camber All Metals After Perforating

Coils and Cut Length Ft.	Commercial Quality	Superior Quality	Special Quality
To 4 Feet Inclusive	1/8"	4' = .062"	
Over 4-6 Ft. Inclusive	3/16"	5' = .098"	
Over 6-8 Ft. Inclusive	1/2"	6' = .140"	

Camber measurement is taken by placing an 8 ft. straight edge on the concave side and measuring the greatest distance between the sheet edge and the straight edge.

Due to the nature of the perforating process, camber can be as great as 2" in 20 ft. when processing coil to coil.

For sheets with wider than standard or unequal side margins, camber must be discussed with the IPA member supplier. Camber doesn't vary in direct proportion to length. Camber is always expressed in 8 ft.

$$\frac{L^2 \times C_1}{8^2} = C_2$$

L^2 = Any Given Length

C_1 = Camber in 8 Ft.

C_2 = Camber in any Given Length

Example: $L^2 = 6$ Ft. (Given Length); $C_1 = .250$ " (1/4")

$$\frac{6^2 \times .250}{8^2 \text{ or } (64)} = \frac{36 \times .25}{8^2 \text{ or } (64)} = \frac{9}{64} = .140"$$

Steel				
Hot Rolled — Hot Rolled Pickled & Oiled				
Gage	Mean of Gage	Min. of Gage	Max. of Gage	Lbs. Per Sq. Ft.
7	.1793	.1713	.1873	7.500
8	.1644	.1564	.1724	6.875
9	.1495	.1415	.1575	6.250
10	.1345	.1265	.1425	5.625
11	.1196	.1116	.1276	5.000
12	.1046	.0966	.1126	4.375
13	.0897	.0827	.0967	3.750
14	.0747	.0677	.0817	3.125
15	.0673	.0613	.0733	2.813
16	.0598	.0538	.0658	2.500
17	.0538	.0478	.0598	2.250
18	.0478	.0428	.0528	2.000